

Date: Friday, 13/02/2009 1:02:20 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM ASSEMBLY
Job Number : 45785	
Estimate Number : 13790	
P.O. Number :	Part Number : D2795044
This Issue : 13/02/2009 S.O. No. :	Drawing Number : D2795 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run :	Material :
Written By :	Due Date : 20/02/2009 Qty: <u>4</u> Um: Each
Checked & Approved By : <u>JLD 09.02.10</u>	
Comment : Est Rev:A New Issue 09-02-11 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .500 x 6.00
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(4)

Comment: Qty.: 1.4438 f(s)/Unit Total : 2.8875 f(s)

6061-T6 Bar .500 x 6.00

BATCH: M110912

Mat not in computer

J.A 09/02/20

2.0	BAND SAW	BAND SAW
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(4)

Comment: BAND SAW

Cut blank 16.500" long

J.A 09/02/20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #11- Mill as per Folio FA803 Rev: B & Dwg D2795 Rev: B

2-Deburr per dwg D2795

J.L 09/02/23

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 09/02/23

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

C/SINK AS PER DWG D2795

J.L 09/02/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector	
09/02/25	7.1	Add Chemical conversion	MS	MO/BR 09/02/25	(14)	[Signature] 09.02.25	[Signature] 09.02.25	
	7.2	Qc3 MS 09-02-25 (X4)	MS			[Signature] 09.02.25	[Signature] 09.02.25	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 13/02/2009 1:02:20 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM ASSEMBLY

Job Number: 45785

Part Number: D2795044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A

09/02/23

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09.02.24 (4)

8.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

BATCH: B41708

(P10)

09/02/25

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
PRESS BUSHING AS PER DWG D2795

09/02/25 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/25 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST151

09/02/26 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



09.02.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

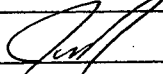
NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45785
Description: arm assembly		Part Number: D2795-4
Inspection Dwg: D2975 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.497	✓			
Ø.191	$\pm .005$ $\pm .001$.193	✓			
2.311	$\pm .010$	2.311	✓			
.800	$\pm .010$.801	✓			
54°	$\pm .5°$	54°	✓			
6.501	$\pm .010$	6.503	✓			
3.88	$\pm .030$	3.88	✓			
15.506	$\pm .010$	15.505	✓			
13.57	$\pm .030$	13.57	✓			
4.32	$\pm .030$	4.320	✓			
.250	$\pm .010$.251	✓			
25°	$\pm .5°$	25°	✓			
2.500	$\pm .010$	2.501	✓			
.250	$\pm .010$.240	✓			
1.125	$\pm .010$	1.125	✓			
.250	$\pm .010$.258	✓			
1.550	$\pm .010$	1.551	✓			
1.080	$\pm .010$	1.080	✓			
1.059	$\pm .010$	1.059	✓			
.100	$\pm .010$.100	✓			
.100	$\pm .010$.101	✓			
.250	$\pm .010$.250	✓			
1.000	$\pm .010$	1.001	✓			

Measured by: J.L.	Audited by: 	Prototype Approval: N/A
Date: 09/02/23	Date: 09.02.24	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 45785
Description: arm assembly		Part Number: D2795-4
Inspection Dwg: D2795-4 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

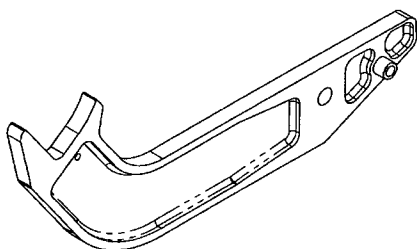
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.347	$\pm .010$	1.347	✓			
.250	$\pm .010$.250	✓			
3.380	$\pm .010$	3.380	✓			
.507	$\pm .001$.5061	✓			
1.032	$\pm .010$	1.032	✓			
.375X100°	$\pm .010$ $\pm .5^\circ$.375X100°	✓			
2.96	$\pm .030$	2.965	✓			
1.626	$\pm .010$	1.626	✓			
.157	$\pm .010$.157	✓			
.625-.575	$\pm .010$.576	✓			
1.00	$\pm .030$	1.000	✓			
.440	$\pm .010$.441	✓			
.625	$\pm .010$.625	✓			
1.250	$\pm .010$	1.250	✓			
2.70	$\pm .030$	2.698	✓			
3.140	$\pm .010$	3.140	✓			

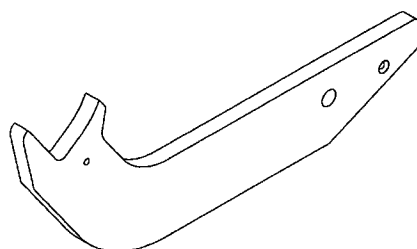
Measured by: J.L.	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/02/23	Date: 09-02-24	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

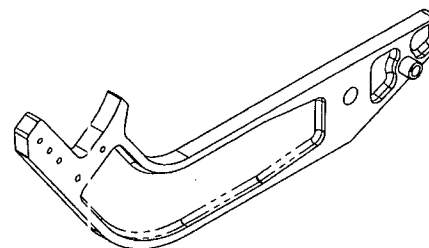
ITEM NO.	QTY. -041	QTY. -042	QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
1	X				D2795-041	ARM ASSEMBLY
2		X			D2795-042	ARM ASSEMBLY
3			X		D2795-043	ARM ASSEMBLY
4				X	D2795-044	ARM ASSEMBLY
11	1				D2795-1	ARM
12		1			D2795-2	ARM
13			1		D2795-3	ARM
15				1	D2795-4	ARM
21	1	1	1	1	D2808	SPACER



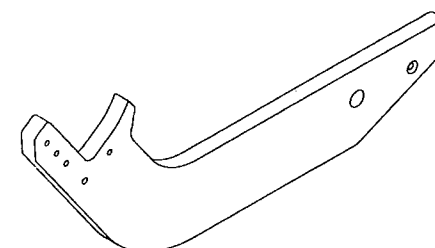
D2795-041 ARM ASSEMBLY



D2795-042 ARM ASSEMBLY



D2795-043 ARM ASSEMBLY



D2795-044 ARM ASSEMBLY

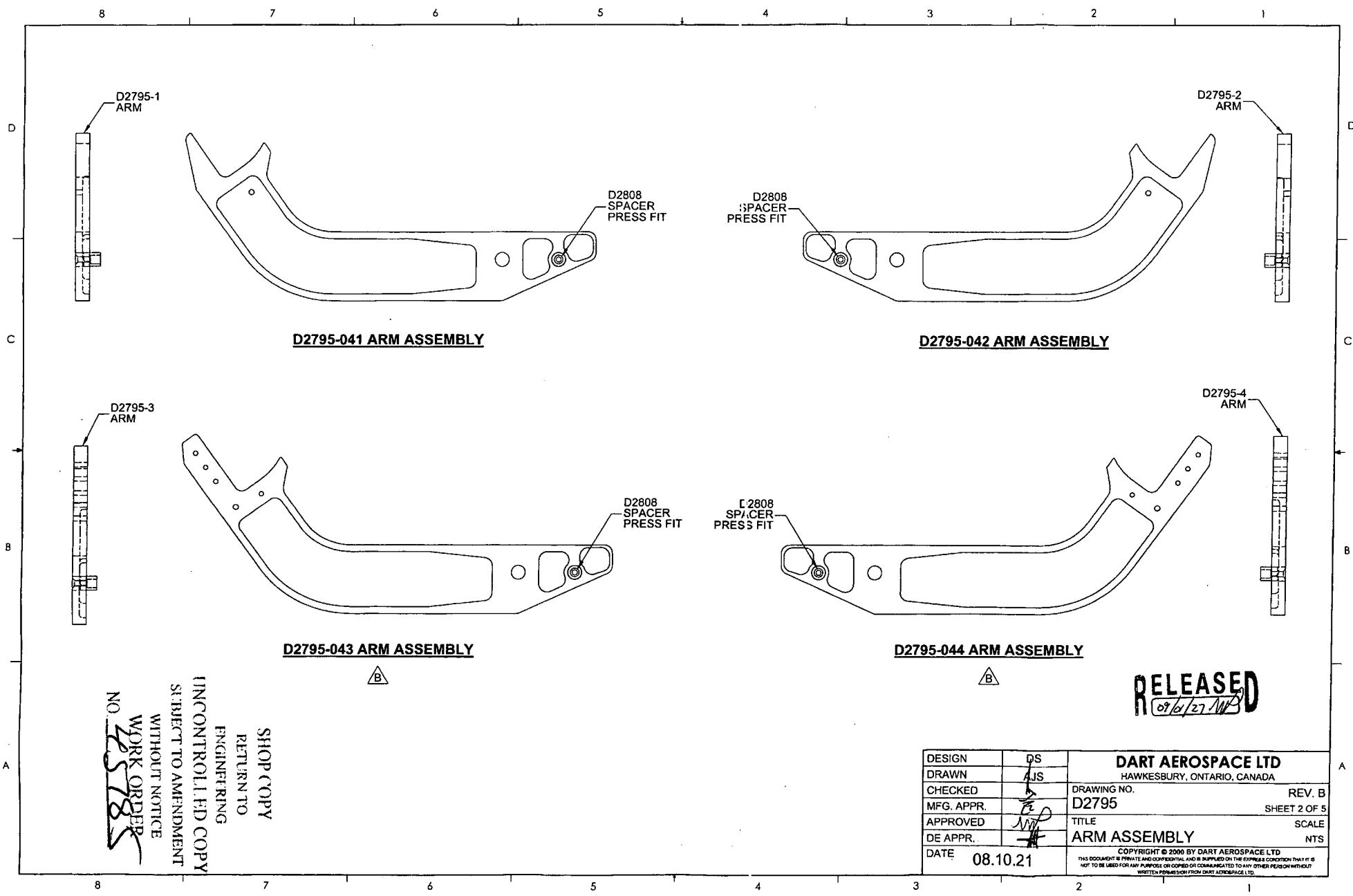
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO 45785

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2795-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D2795-041/-042 1.22 lbs
D2795-043/-044 1.29 lbs

B	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. -1 & -2 PARTS HAD NO PHYSICAL CHANGES BUT WERE REDIMENSIONED. SEE PREVIOUS REV FOR DETAILS. -043, -044 -3 & -4 ADDED. MATERIAL SPECS UPDATED.		AJS	08.10.21
A	NEW ISSUE		DS	00.11.03
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D2795	SHEET 1 OF 5	
APPROVED		TITLE	SCALE	
DE APPR.		ARM ASSEMBLY	NTS	
DATE	08.10.21			

RELEASED
09/01/21



D2795-041 ARM ASSEMBLY

D2795-042 ARM ASSEMBLY

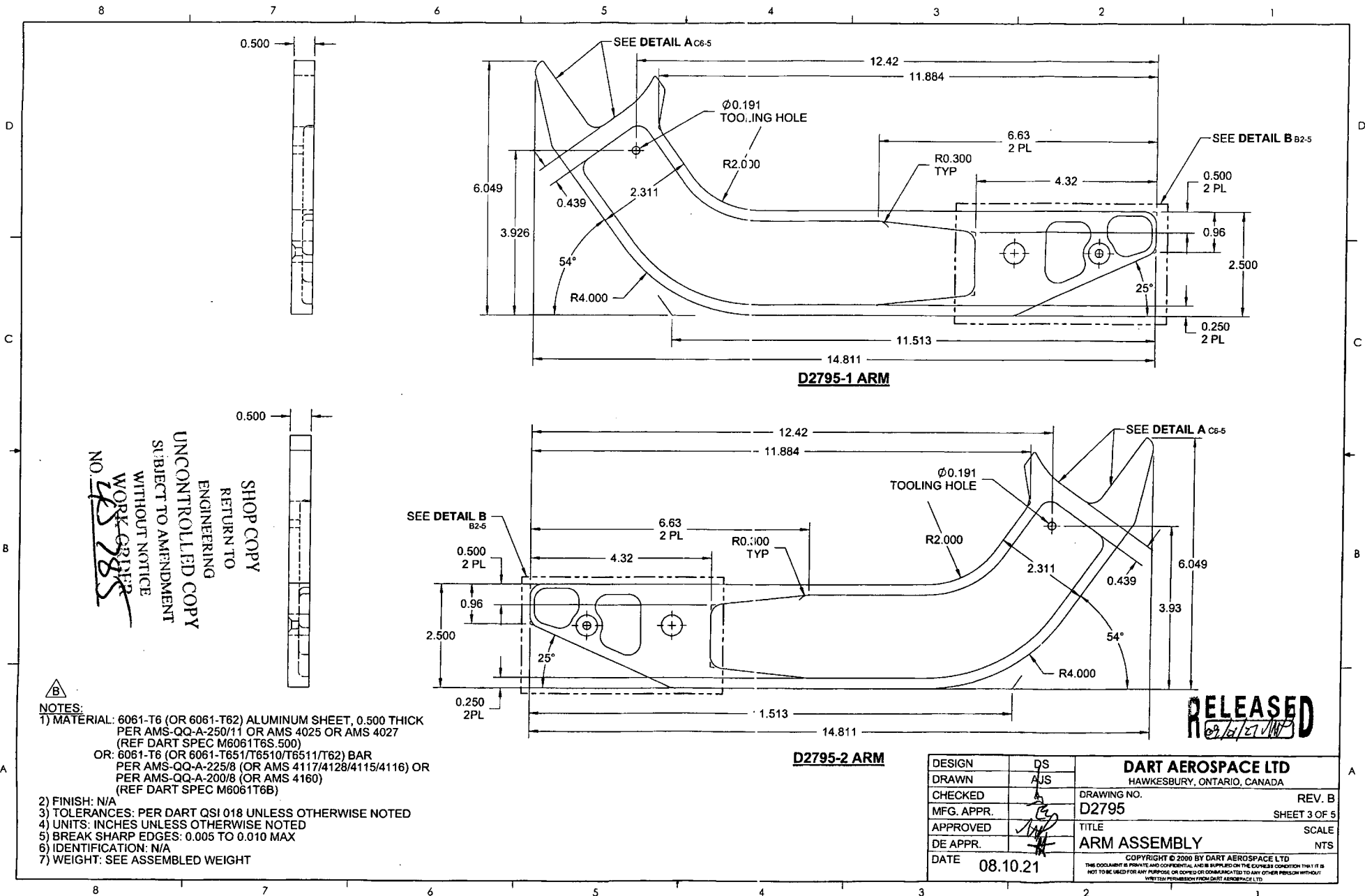
D2795-043 ARM ASSEMBLY

D2795-044 ARM ASSEMBLY

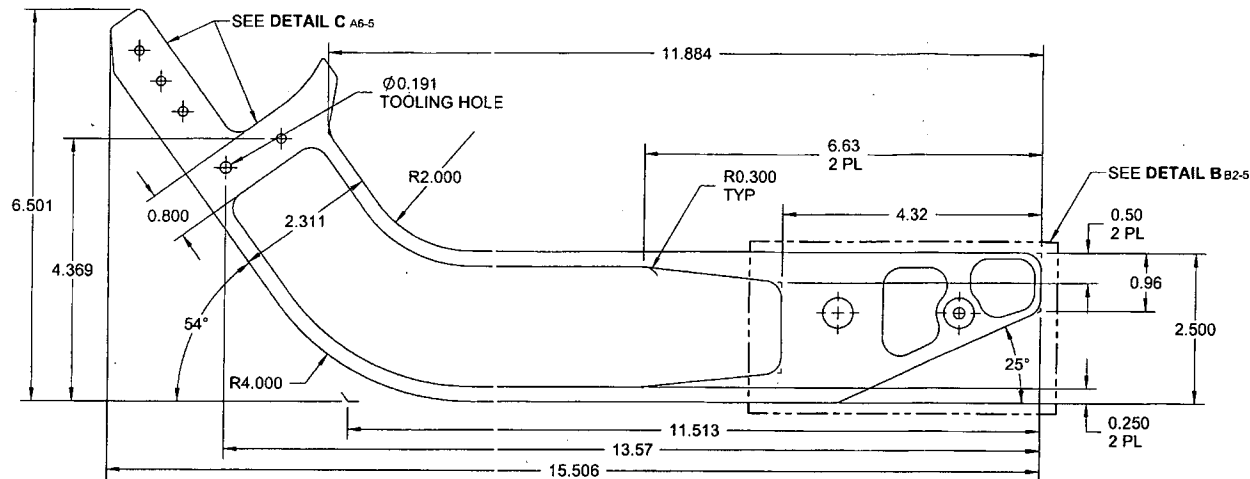
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09/01/27 MJB

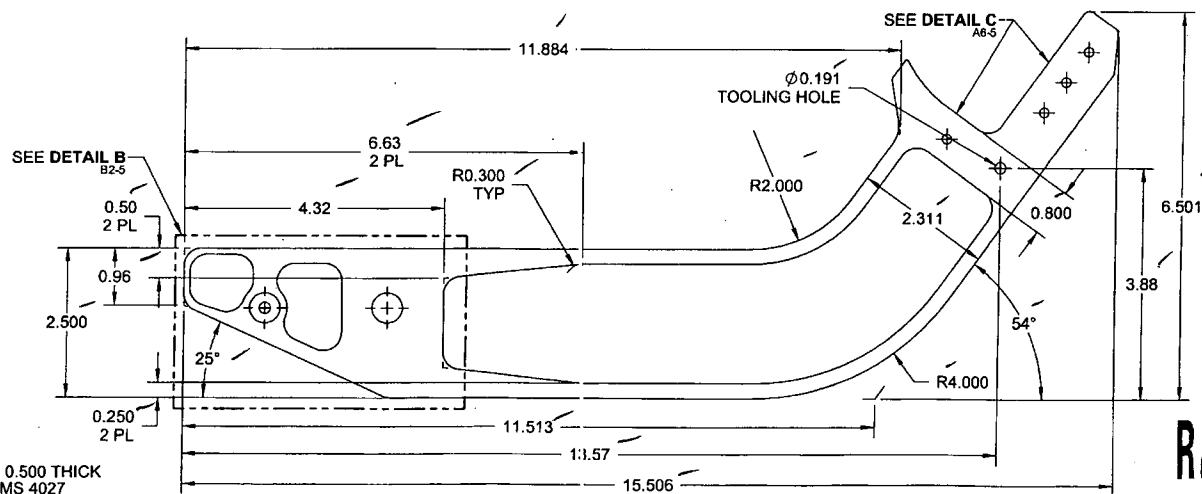
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DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D2795	SHEET 2 OF 5
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	ARM ASSEMBLY	NTS
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DRAWN	AJS		
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MFG. APPR.		D2795	SHEET 3 OF 5
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D2795-3 ARM

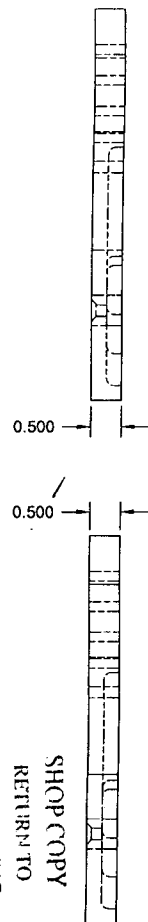


D2795-4 ARM

RELEASED
09/16/17 JMD

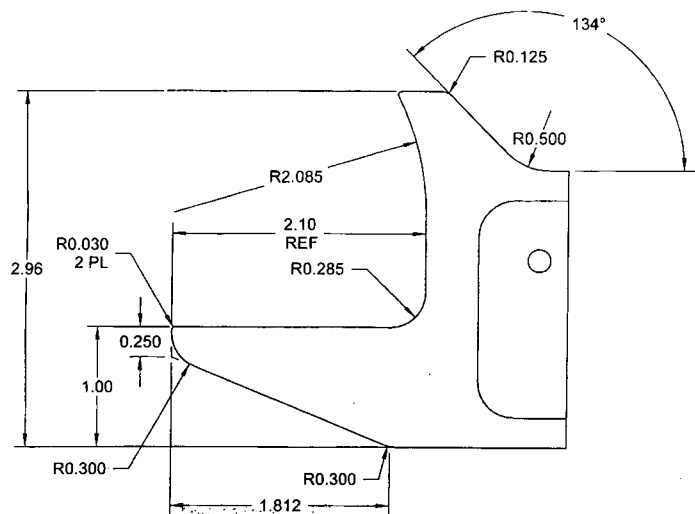
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.500 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.500)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE ASSEMBLED WEIGHT

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D2795	SHEET 4 OF 5
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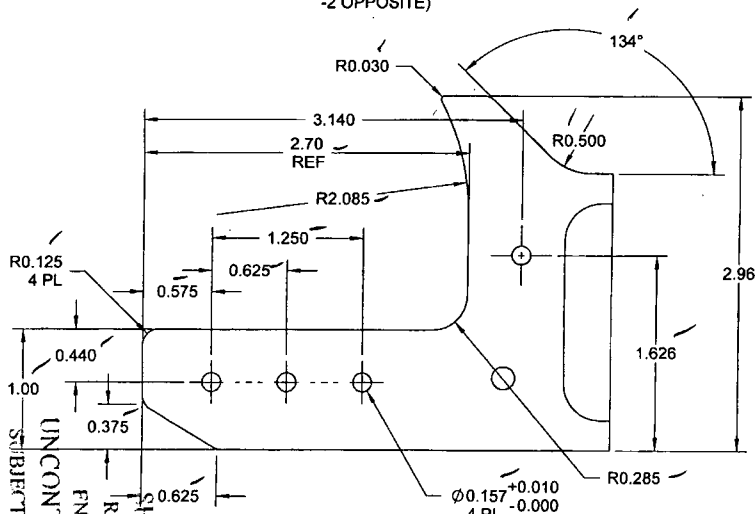


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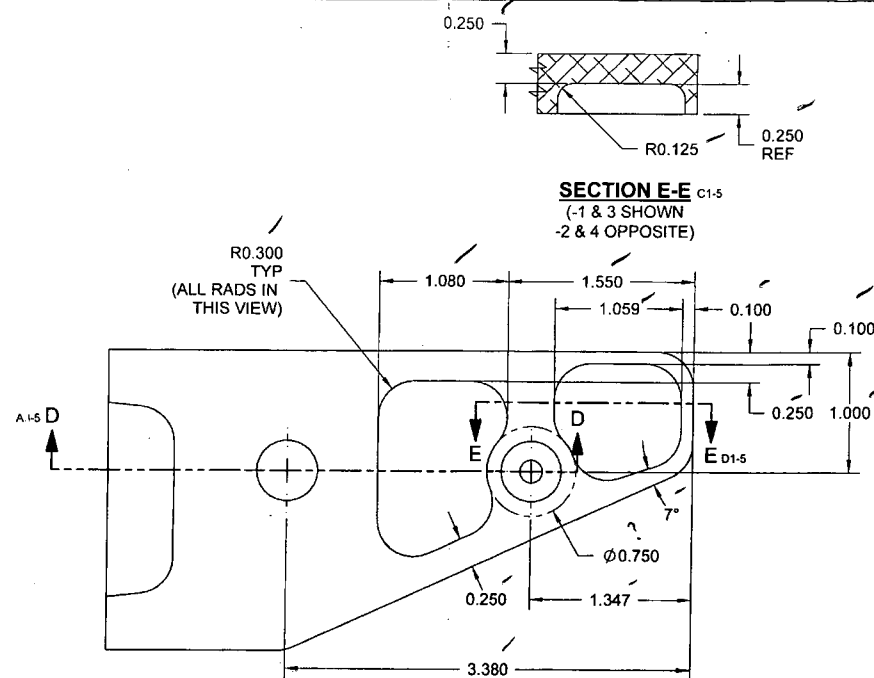
NO. 45785
W. J. JORDAN



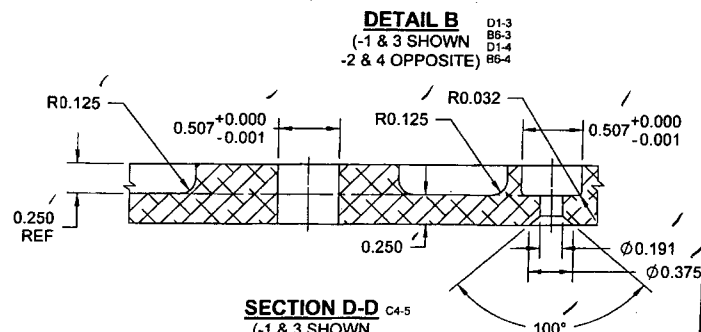
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C1-3
(-1 SHOWN
-2 OPPOSITE)



DETAIL C C2-4
05-4
(-3 SHOWN
-4 OPPOSITE)



SECTION E-E C1-5
(-1 & 3 SHOWN
-2 & 4 OPPOSITE)



SECTION D-D C4-5
(-1 & 3 SHOWN
-2 & 4 OPPOSITE)

RELEASED
09/07/00

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.			SHEET 5 OF 5
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